

Date: Tuesday, 08/04/2008 12:53:02 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE	
Job Number : 38470		
Estimate Number : 13168		
P.O. Number :	Part Number : D37411	
This Issue : 08/04/2008 S.O. No. :	Drawing Number : D3741 REVB	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B	
Previous Run : 38224	Material :	
Written By :	Due Date : 15/04/2008	Qty: 8 Um: Each
Checked & Approved By : <u>JD 08.4.08</u>		
Comment : Est Rev:A 08-01-30 new issue DD verified by: Est Rev:B 08-03-19 chg to revB DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6207	Angle Extrusion 1x1x.125
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Comment: Qty.: 0.0656 f(s)/Unit Total: 0.5250 f(s)

D6207 angle extrusion

Batch: M18147

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: 1-drill holes as per dwg D3741

2-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3741

2- Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 12:53:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 38470

Part Number: D37411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/04/11 x 9

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 08-04-11 (x9)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS BK 08-04-11

(9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 117

AS 08/04/11

(x9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15

Job Completion



mf 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

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D

C

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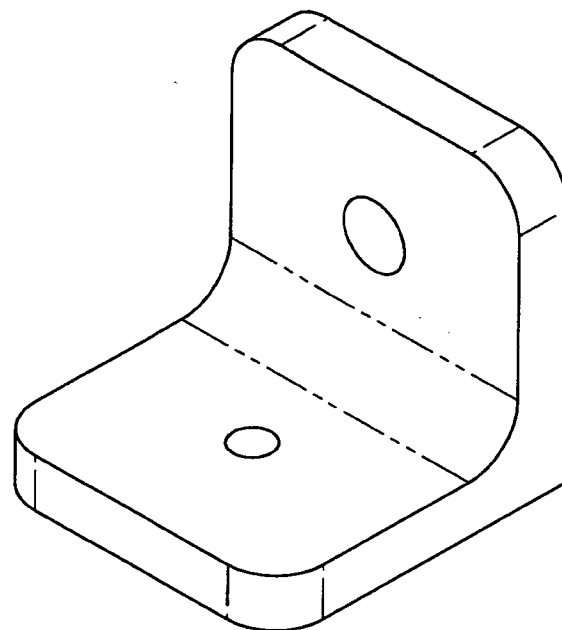
A

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D3741-1 ANGLE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38470

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED. SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B 0.440 DIM WAS 0.450.	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3741	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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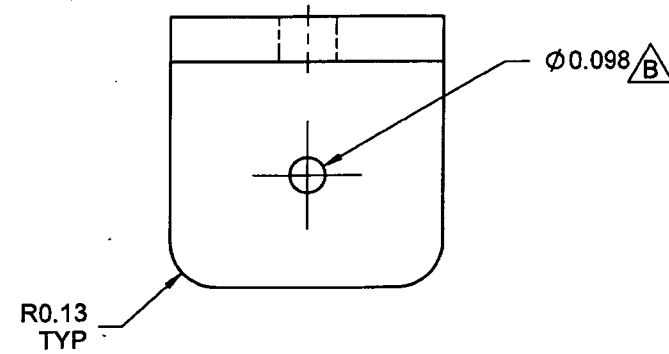
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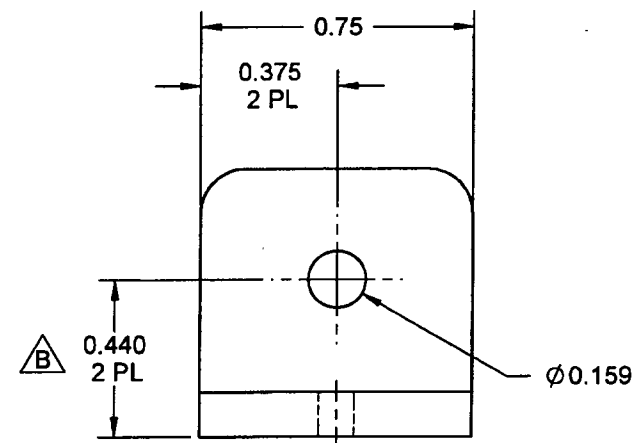
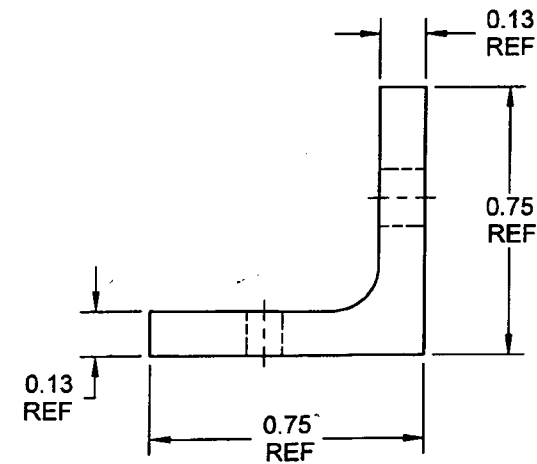
D

D



C

C

**D3741-1 ANGLE**

B

A

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WORK ORDER
NO. 38470

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D3741	SHEET 2 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>HA</i>	ANGLE	NTS
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2

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FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

[illegible]

Measured by: <i>[Signature]</i>	Audited by: <i>LF</i>	Prototype Approval:
Date: <i>08-04-10</i>	Date: <i>08/04/10</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	